



Dart Aerospace Ltd.
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Tel (613) 632-5200

D3643-2

Job Sheet 180856



Part No: D3643-2

Job Qty: 12 ea

Part Name: Stiffener



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 8/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		8/10/18	0.00	0.00	Start Up Waterjet		SC 18/07/21
100	Waterjet	12 pcs		8/10/18	0.00	0.61	Waterjet1		SC 18/07/21
110	QC	12 pcs		8/10/18	0.00	0.00	QC2 Waterjet-2		SC 18/07/21
120	QC	12 pcs		8/10/18	0.00	0.00	QC8-3		38
130	Brake NC	12 pcs		8/10/18	0.00	0.34	Brake NC 2		9-89
140	Small Fab	12 pcs		8/10/18	0.00	0.49	Small Fab-4		PD 10-07-31
150	QC	12 pcs		8/10/18	0.00	0.00	QC5		SA 18-07-31
160	HandFinish	12 pcs		8/10/18	0.00	0.56	HandFinish1		18-08-32
170	QC	12 pcs		8/10/18	0.00	0.00	QC7-2		6
180	Packaging	12 pcs		8/10/18	0.00	0.00	Packaging3-1		57846 9-89
190	QC21-SA	12 Ea		8/10/18	0.00	0.00	QC21		AUG 08 2018

Part Op 100 - 1-Cut as per Dwg D3643 Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per Dwg D3643

140 - C'sink as per Dwg D3643

150 - QC5- Inspect part completeness to step on W/O

160 - Chemical Conversion Coat per QSI005 4.1

170 - QC7-Inspect Chemical Conversion Coat

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

DAS 21
9-89
AUG 08 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	1.7700 sf (.1475 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	2	107	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected U		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		Part: D3643-2 Job No: 180856 Serial No/Batch: S094748 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/21/18					
Description Work Order Deviation									
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Force ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		and Wrong ☐ Dimensions ☐ Under tolerance ☐ Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER : _____							

